

Date: Thursday, 24/04/2008 10:26:05 AM
 User: Linda Lacelle

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : CLEVIS |
| Job Number : 38773 | |
| Estimate Number : 10104 | |
| P.O. Number : | Part Number : D2012107C |
| This Issue : 24/04/2008 S.O. No. : | Drawing Number : D2012-107 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SMALL /MED FAB | Drawing Revision : C |
| Previous Run : 33585 | Material : |
| Written By : <u> </u> | Due Date : 01/05/2008 Qty: 1 Um: Each |
| Checked & Approved By : <u> </u> | |
| Comment : Est: D 01.11.08 Re-format, Drawing to Rev. C SM Est Rev:E Now on Waterjet 06-06-13 JLM | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|------------|-------------------------|
| 1.0 | M1010S16GA | 1010/1025/A21/6aA SHEET |
|-----|------------|-------------------------|



Comment: Qty.: 0.0168 sf(s)/Unit Total : 0.0168 sf(s)
 304/316 .063 Sheet
 (M304S063)
 Batch: 101948 1B8-4-24

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
 1-Cut as per Dwg D2012-107
 Dwg Rev: C
 Prog Rev: C

1B8-4-24

(3)

2-Deburr if necessary

SB 08/04/24

(3)

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1B8-4-24

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

SB 08/04/24 (43)

| | | |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE

Form on press using DT8242 as per Dwg D2012-107

SB 08/04/24 (3)

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 38773

Part Number: D2012107C

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/04/28 (43)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

08/04/28 (3)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/28

Job Completion

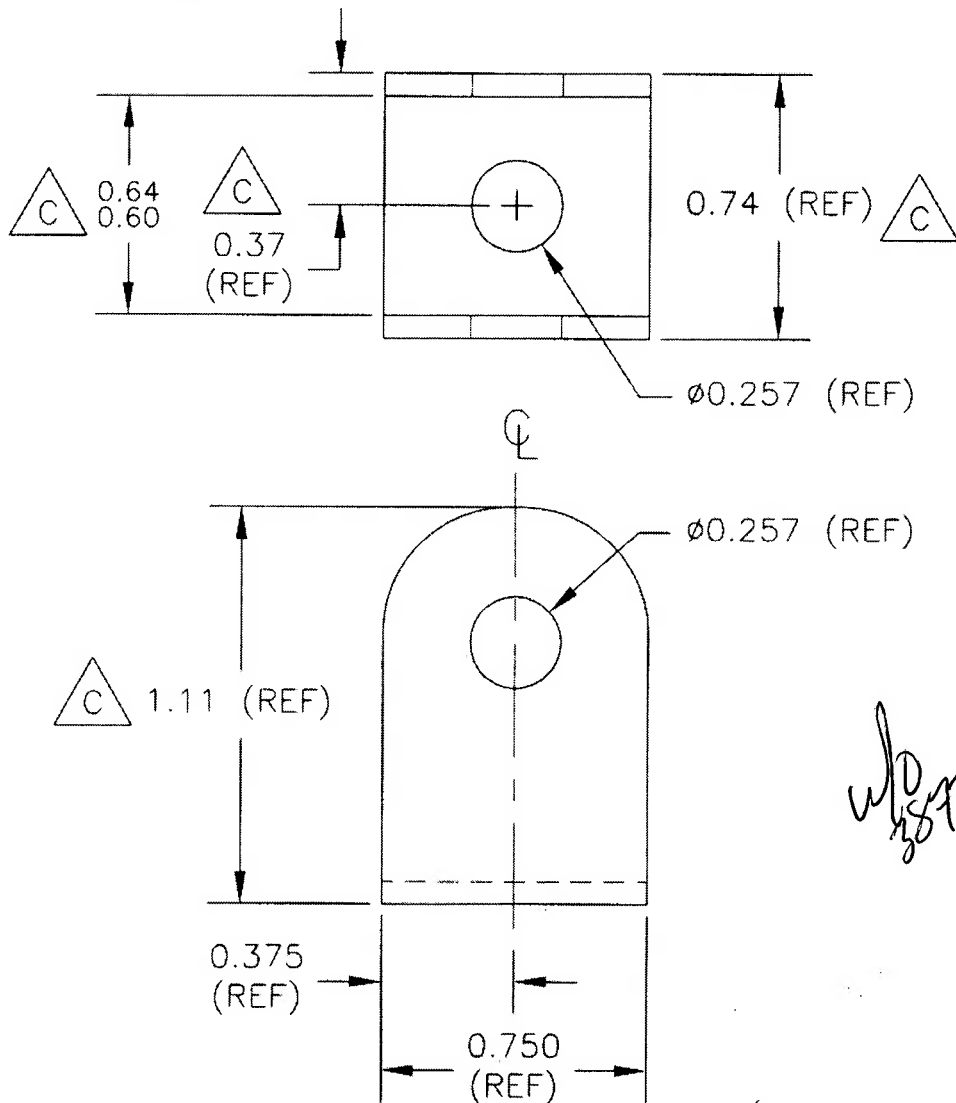


U 08-04-28



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN BW | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2012-107 | REV. C SHEET 1 OF 2 |
| DATE 99.12.20 | | TITLE CLEVIS | SCALE 2:1 |
| A | 94.10.27 | NEW ISSUE | |
| B | 99.04.30 | ADD FLAT PATTERN | |
| C | 99.12.20 | 0.74 WAS 0.680 | |

RELEASED
00.01.04 DS

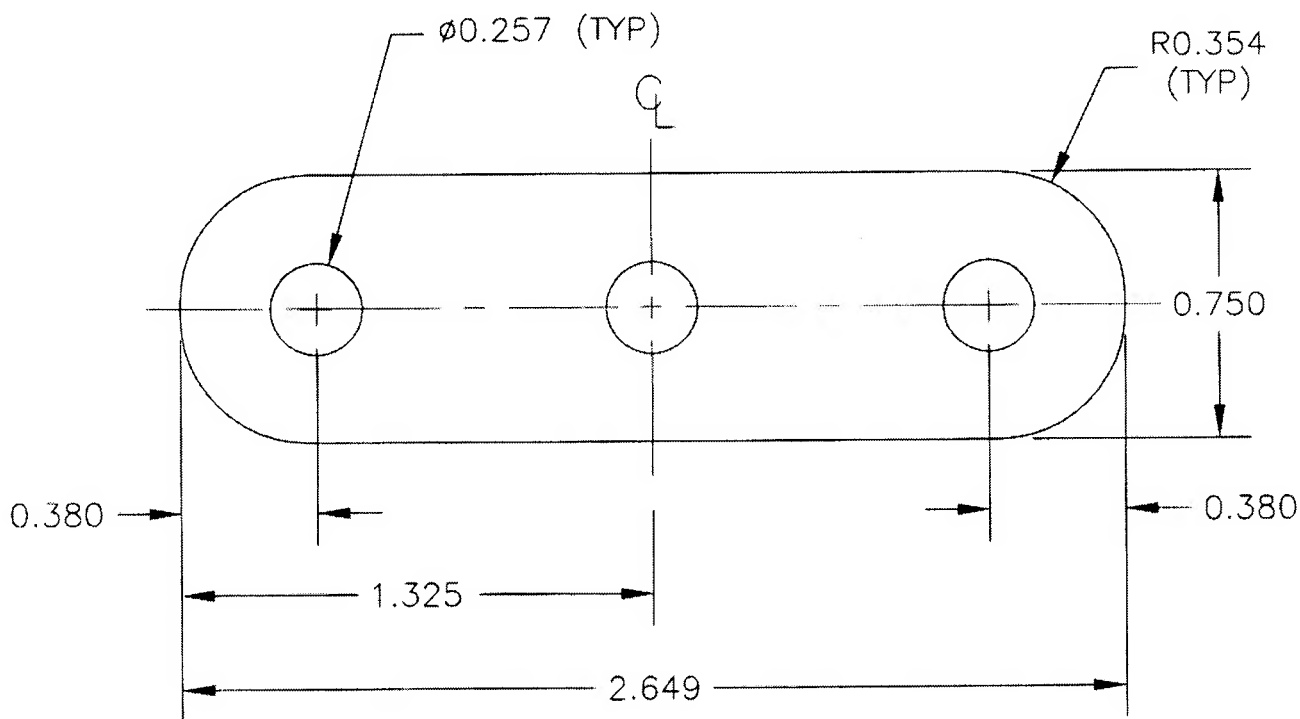


MATERIAL: AISI ~~304/316~~ SS ~~0.063~~ THICK *1010 16GA (one time only per ECN176)*
USE 0.032 BEND RADIUS
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN BW | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2012-107 | REV. C SHEET 2 OF 2 |
| DATE 99.12.20 | | TITLE CLEVIS | SCALE 2:1 |

RELEASED
00 01-04 DS



D2012-107 FLAT PATTERN

1010 mild steel 16GA (one time only per ECN 1176)
MATERIAL: AISI ~~304/316~~ SS 0.063 THICK
TOLERANCES ARE DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

